

Work Order ID 151989

Friday, October 14, 2016 1:56:38 PM

151989

Page 1

Item ID: D2580-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 205 Bent Tube
Start Date: 10/11/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **OCT 17 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	G								

100

0.00

100

Skidtubes

Skidtubes

Memo

0.25

1- Inspect mat'l D2500-1-190 for damage.

2-Drill pilot holes using drill jig DT 8149 A-BC-D

3-Open holes to 0.508" as per Dwg D2580

4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube

5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.

101

QC6- Inspect dimensions to drawing

0.00

101

QC

Quality Control

Memo

0.00

16-11-23 DT
4 16-11-23
DAS 18 9-89

Work Order ID 151989

Friday, October 14, 2016 1:56:38 PM

151989

Page 2

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Required Date: 10/14/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.17				4	Ø	16-11-24	DAS 19 9-89
120 *120* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.01						16-11-24	DAS 03 9-89
125 *125* Skidtubes Skidtubes	 Memo 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: <u>B136093</u> Sikaflex expire date: <u>17-02-16</u> Start time and date: <u>10:30</u> bond for 12hrs	0.00 0.16				4	Ø	16-11-25	

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC5- Inspect part completeness to step on W/O	0.00							
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130

QC

Quality Control

Memo

0.01

DAS
03
9-89

16-11-28

140	Identify as per dwg & Stock Location: LG002	0.00							
-----	--	------	--	--	--	--	--	--	--

140

Packaging

Packaging

Memo

LOCATION : LG002

0.01

4 0 16-11-25

150	QC21- Final Inspection - Work Order Release	0.00							
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150

QC

Quality Control

Memo

0.07

DAS
21
9-89

NOV 2 R 2016

DAS
21
9-89

NOV 2 R 2016

Picklist Print

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Page 1

Work Order ID: 151989

151989

Parent Item: D2580-1

D2580-1

Parent Item Name: 205 Bent Tube

Start Date: 10/11/2016

Required Date: 10/14/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C
10.12.01 as per DEO D1 DD verf:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190 *D2500-1-190* Ext'n -T Beam Tube 4"		Manufactured	No			100	Each	50.0000	1	4			
									**	16-11-23 DJ			
					<u>Location</u> HALL 151612 145247			<u>Loc Qty</u> 50 50		<u>Loc Code</u>			
D2596 *D2596* Web, 205 Skidtube		Manufactured	No			100	Each	10.0000	1	4			
									**	16-11-25 Jk			
					<u>Location</u> LG002 147904 148885 150934			<u>Loc Qty</u> 10 2 4 4		<u>Loc Code</u>			
										4			

LIST OF MATERIALS							
ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION	
1	X				D2580-041	SKIDTUBE ASSEMBLY	
2		X			D2580-045	SKIDTUBE ASSEMBLY	
3			X		D2580-047	SKIDTUBE ASSEMBLY	
4				X	D2580-049	SKIDTUBE ASSEMBLY	
20	1	1	1	1	D2500-1-190	EXTRUSION	
21			16	16	D2570	BUSHING	
22	1	1	1	1	D2576-3	STEP	
23		4			D2579	SPACER	
24	16	16	8	8	D2594-1	PLUG	
25	16	16	8	8	D2594-3	O-RING	
26	1	1	1	1	D2596	205 WEB	
27	1	1	1	1	D2855	AFT CAP	
28	1	1			D3564-5	WEARSHOE	
29	1	1			D3564-9	WEARSHOE	
30	1	1			D3564-11	WEARSHOE	
31	1	1			D3564-13	WEARSHOE	
32	2	2			D3566-1	GASKET	
33	1	1			D3566-5	GASKET	
34	1	1			D3566-13	GASKET	
35	20	20	24	24	D4202-1	SPACER	
36			1		D4408-041	WEARPLATE ASSEMBLY	
37			1		D4406-043	WEARPLATE ASSEMBLY	
37				1	D5061-1	FWD WEARPLATE	
37				1	D5061-3	AFT WEARPLATE	
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT	
51	50	50			AN3C4A	BOLT	
52	2	2	2	2	AN3-5A	BOLT	
53			8	8	AN4-45A	BOLT	
54	50	50			NAS1149C0332R	WASHER (AN960C10L)	
55	2	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)	
56			8	8	MS21042-4	NUT (OR MS21042L4)	

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT ASSEMBLY (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.287 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

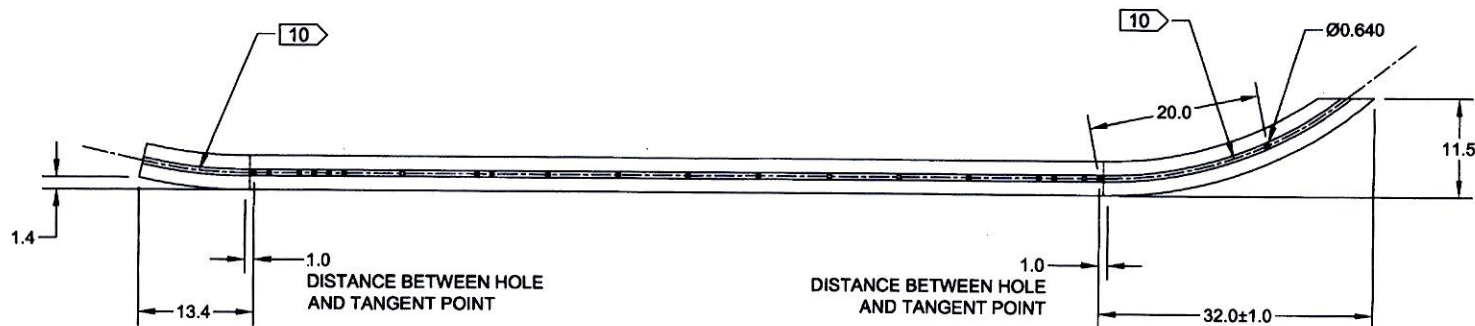
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16-1077

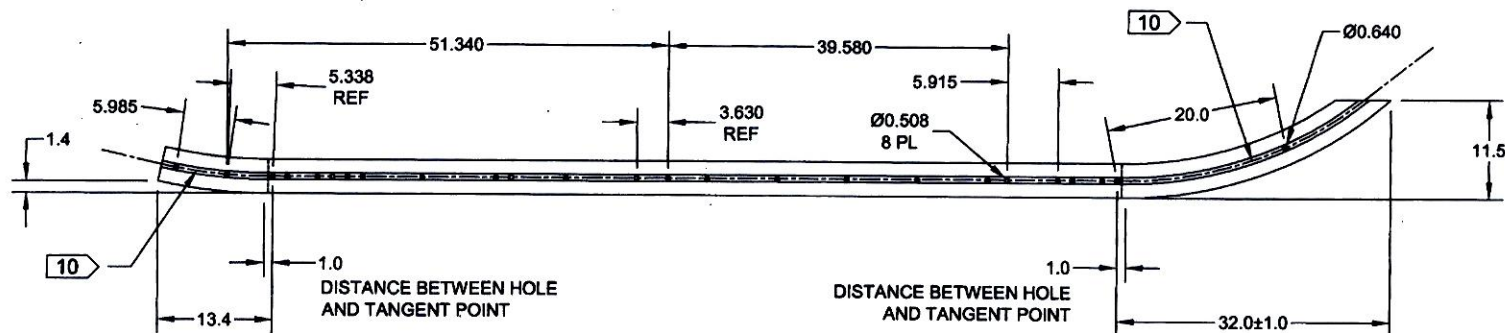
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9588	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.K.	DRAWING NO.	REV. G
MFG. APPR.	N	D2580	SHEET 1 OF 9
APPROVED	19	TITLE	SCALE
DE APPR.	2	205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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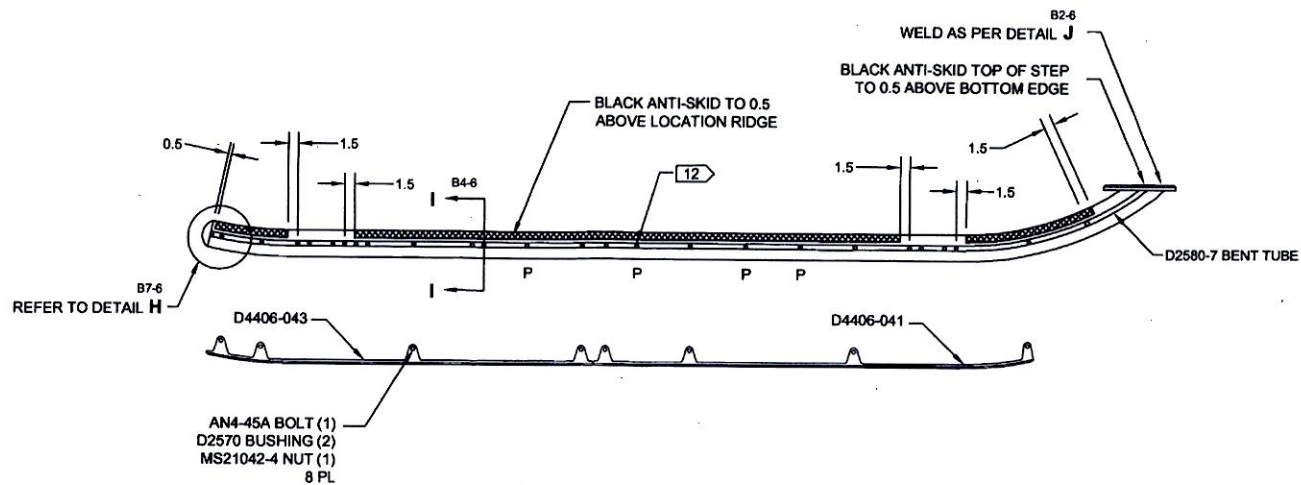
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MFG. APPR.		D2580	SHEET 3 OF 9
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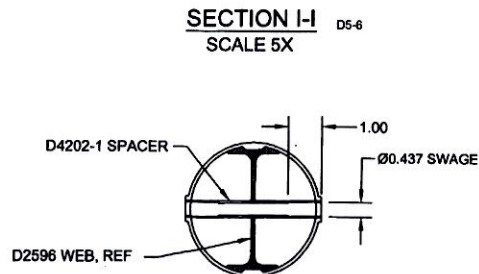
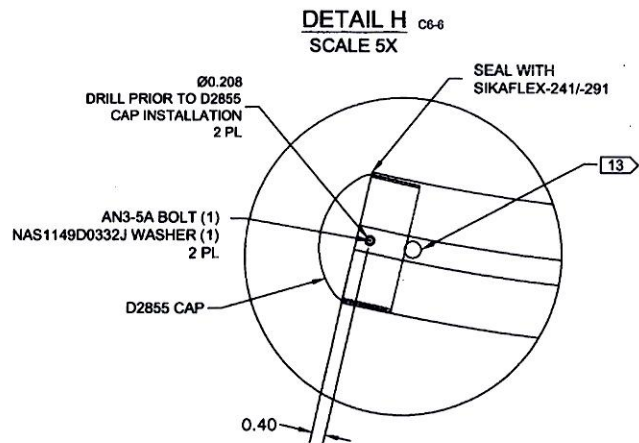
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 5 OF 9
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DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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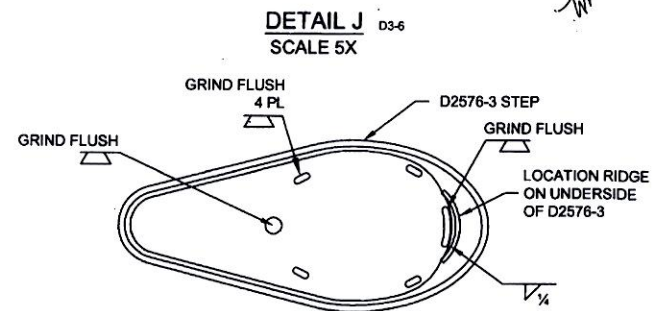


D2580-047 ASSEMBLY DETAIL



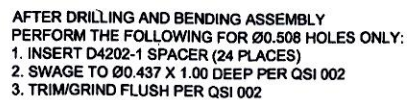
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

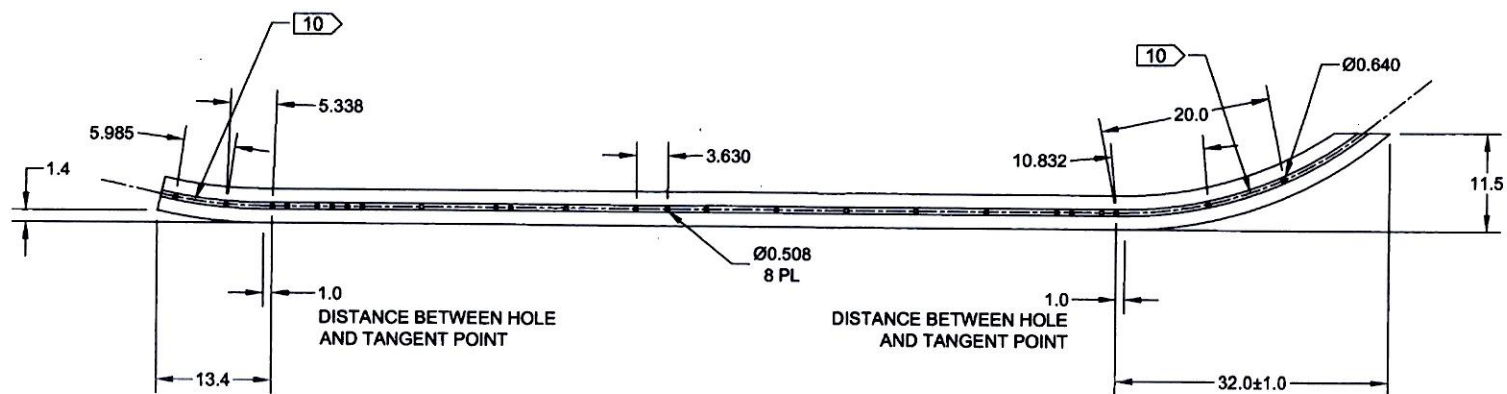


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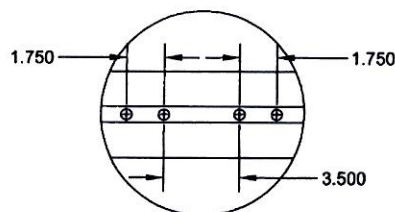
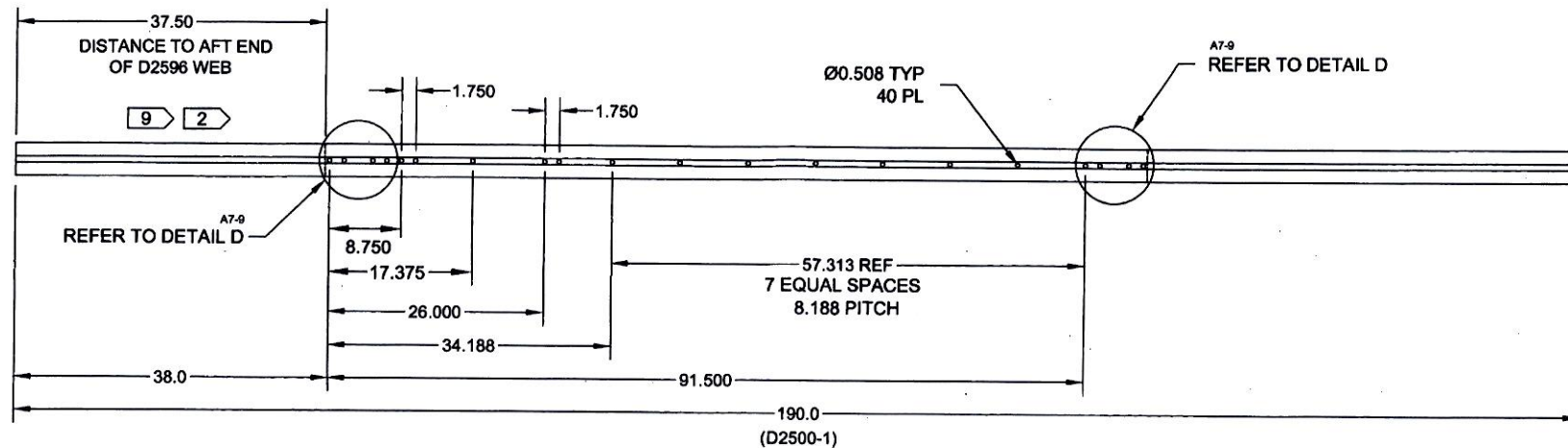
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MFG. APPR.	<i>AS</i>	D2580	SHEET 7 OF 7
APPROVED	<i>AS</i>	TITLE	SCALE
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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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DETAIL D C3-9
SCALE 5X C7-9

D2580-101 TUBE

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